

Work Order ID 77716

77716

Page 1

December-19-11 8:23:31 AM

Item ID: D3011-1

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Rappel

Start Date: 19/12/2011 Start Qty: 8.00

8

Cust Item ID:

Required Date: 02/01/2012 Req'd Qty: 8.00

8

Customer:

Reference:

Approvals:

Process Plan: M.L.S

Date: 11/12/11

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr

Revision Nbr

D3011

Rev B

100

0.00

100

BAND SAW

Bandsaw

Memo

0.00

Jeaspa Bandsaw

Cut Blanks: 26.625"

85 12-01-17 (X8)

110

0.00

110

HAAS CNC VERTICAL MACHINING #1

HAAS 1

Memo

0.00

HAAS CNC vertical machine #1

Oil/B.A. 12/01/20

8 φ

Machine as per folio FA129

Folio Rev: AA

Dwg Rev: B

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 77716

December-19-11 8:23:32 AM

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N900040100Setup Start ***NS1***

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Stop ***NS2***

Item Name: Rappel

Start Date: 19/12/2011 Start Qty: 8.00

8

Cust Item ID:

Required Date: 02/01/2012 Req'd Qty: 8.00

8

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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120

QC2- Inspect parts off machine FAI/FAIB

0.00

120

QC

Memo

0.00

Quality Control

SL/B.N 12/01/20

8

φ

130

QC8- Inspect parts - second check

0.00

130

QC

Memo

0.00

Quality Control

SL 12-01-22

⑧

131

0.00

131

Outsource2

Memo

0.00

Outsource process - NDT

1- LPI AS PER ASTM 1417 LEVEL 2 AS PER DWG d3011
2- Certificate of conformity is required

6/2/01/09 ⑧

W/O:		WORK ORDER CHANGES					
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Item ID: D3011-1 Accept ***N900040100*** Setup Start ***NS1***
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 Item Name: Rappel
 Start Date: 19/12/2011 Start Qty: 8.00 ***8*** Cust Item ID:
 Required Date: 02/01/2012 Req'd Qty: 8.00 ***8*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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132 *132* QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00		8 12/01/24		80			
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140 *140* HandFinish Hand Finishing	Chemical Conversion Coat per QSI005 4.1 Memo	0.00 0.00					8 12-1-24		
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150 *150* Powdercoat Powder Coating	White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum Memo START TIME: 11:30 OVEN TEMPERATURE: 3200F FINISH TIME: 12:00	0.00 0.00						8XØ M-12/01/24	
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m11a480

W/O:		WORK ORDER CHANGES					
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Item Name: Rappel
Start Date: 19/12/2011 Start Qty: 8.00 ***8*** Cust Item ID:
Required Date: 02/01/2012 Req'd Qty: 8.00 ***8*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160 *160* QC Quality Control	QC3- Inspect Part Finish Memo	0.00 0.00							<u>8</u> <u>12-1-24</u>
170 *170* Packaging Packaging	Identify as per dwg & Stock Location: <u>8</u> Memo	0.00 0.00							<u>12/01/24</u> <u>(8)</u>
180 *180* QC Quality Control	QC21- Final Inspection - Work Order Release Memo	0.00 0.00							<u>12/1/24</u> <u>(8)</u>

130.5 ISSUE PO 15967

12-01-23
(8)

W/O:		WORK ORDER CHANGES					
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NOTE: Date & initial all entries

December-19-11 8:23:35 AM

Page 1

77716

D3011-1

Required Date: 02/01/2012

Required Qty: 8.00

Comments: IPP C02.05.09Added D6202 at step 2NG
IPP Rev:D Added QC8 JLM Verified By:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D6202		Manufactured	No			110	f	0.0000	1	8			
D6202						77710			**	ET		12-01-17	

W/O:		WORK ORDER CHANGES					
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DART AEROSPACE LTD		Work Order:	77716
Description: Rappel Slide Bar		Part Number:	D3011-1
Inspection Dwg: D3011-1 Rev: B		Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ **First Article**

 ☐ **Prototype**

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
26.41	+/-0.030	26.410	✓		Tape	GA-12
2.31	+/-0.030	2.306	✓		Vern	GA-01
2.36	+/-0.030	2.360	✓		"	"
1.120	+0.030/-0.010	1.119	✓		"	"
1.685	+0.030/-0.010	1.683	✓		H-6	31006
1.745	+0.030/-0.010	1.766	✓		"	"
1.250	+0.030/-0.010	1.249	✓		Vern	GA-01
2.500	+0.030/-0.010	2.519	✓		H-6	31006
2.125	+0.030/-0.010	2.146	✓		"	"
0.275	+0.030/-0.010	0.279	✓		Vern	GA-01
0.375	REF	0.373	✓		H-6	31006
Ø0.386	+0.006/-0.001	Ø0.386	✓		Vern	GA-01

Measured by: BA	Audited by: J	Prototype Approval:	N/A
Date: 12/01/20	Date: 12-01-22	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	09.05.04	New Issue	KJ/DD	
B	09.09.14	Dimensions revised per Dwg Rev B	KJ	

Dart Aerospace Ltd

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RELEASE
09/07/25

W/O:		WORK ORDER CHANGES					
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LIQUID PENETRANT TEST REPORT

P- 12251

CLIENT DART Aerospace DATE JANUARY 23-2005 TIME AM ☒ PM ☐
ATTENTION LINDA LACELLE ACUREN JOB NO. 188-12-C0014
ADDRESS 1270 ABELDEEN ST. POWO No. -
HAWKES BUNT, ON WORK LOCATION SAME
PROJECT FPI ON MACHINED PARTS ACCEPTANCE STD ASTM 1417/651-03B REV./DATE 2005
ITEM(S) EXAMINED (S)

JOB DESCRIPTION PROCEDURE NO. LT 602 REV/DAT 2005 TECHNIQUE NO. LT 602 REV/DAT 2005
PART NO. SEE RESULTS MATERIAL Aluminum THICKNESS 1/4 inch
SCOPE GET FLUORESCENT LIQUID PENETRANT INSPECTION WAS
CONDUCTED ON 100% EXTERNAL SURFACE

TEST DETAILS
METHOD ☒ FLUORESCENT ☐ VISIBLE ☒ WATER WASH ☐ SOLVENT REMOVABLE ☐ POST EMULSIFIED
FAMILY BRAND WYNAFLEX BLACK LIGHT S/N 16959 ☐ OUTPUT > 1000 μ W/cm² ☐ AMBIENT < 2 fc
PENETRANT Z-67 MINIMUM DWELL TIME 5-10 MIN. LIGHTING EQUIP. ☐ FLASHLIGHT ☐ TROUBLELIGHT ☐ OUTPUT > 100 fc @ SURFACE
PENETRANT REMOVER H-70 MINIMUM DRY TIME > 10 MIN. OTHER L-4340
DEVELOPER PKD 52 MINIMUM DWELL TIME 10 MIN. LIGHT METER S/N 1058866 CAL DUE DATE 2012
DEVELOPER TYPE ☒ NON AQUEOUS ☐ AQUEOUS ☐ DRY

TEST SURFACE
SURFACE CONDITION ☐ AS GROUND ☐ AS WELDED ☒ MACHINED ☐ SHOT BLASTED ☒ CLEAN BARE METAL
SURFACE TEMPERATURE ☐ < -4°C/ 20°F ☐ -4°C/ 20°F TO 10°C/50°F ☐ 10°C/50°F TO 52°C/125°F ☐ > 52°C/125°F

RESULTS- ☐ METRIC ☐ IMPERIAL

8 W.C. 77716-LAPPEL ✓
S. 216124
P. 24/1/05

Scope of Services
The agreement of Acuren Group Inc. to perform services extends only to those services provided for in writing. Under no circumstances shall such services extend beyond the performance of the requested services. It is expressly understood that all descriptions, comments and expressions of opinion reflect the opinions or observations of Acuren Group Inc. based on information and assumptions supplied by the owner/operator and are not intended nor can they be construed as representations or warranties. Acuren Group Inc. is not assuming any responsibilities of the owner/operator and the owner/operator retains complete responsibility for the engineering, manufacture, repair and use decisions as a result of the data or other information provided by Acuren Group Inc. In no event shall Acuren Group Inc.'s liability in respect of the services referred to herein exceed the amount paid for such services.
In performing the services provided, Acuren Group Inc. uses the degree, care and skill ordinarily exercised under similar circumstances by others performing such services in the same or similar locality. No other warranty, expressed or implied, is made or intended by Acuren Group Inc.

SIGNATURES
CLIENT REPRESENTATIVE [Signature] DTR # E-76724
TECHNICIAN (SIGNATURE): [Signature] REPORT REVIEWED BY:
NAME INITIALS
NAME (PRINT): Mike T. Hossler
1st TECHNICIAN 2nd TECHNICIAN
CGSB LEVEL SNT LEVEL CGSB LEVEL SNT LEVEL
CGSB REG. No. 6606 CGSB REG. No.

WHITE - CLIENT COPY

CANARY - OFFICE COPY

PINK - TECHNICIAN COPY

GOLD - OFFICE COPY